

Date: Thursday, 3/30/2006 10:05:37 AM
 User: Kim Johnston

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26443 *2*
 Estimate Number : 10495
 P.O. Number : *NIA*
 This Issue : 3/30/2006 S.O. No. : *NIA*
 Prsht Rev. : NC
 First Issue : *NIA* Type : MACHINED PARTS
 Previous Run : *NIA*
 Written By : *SEE COMMENT BELOW*
 Checked & Approved By : *06.03.30*
 Comment :

Drawing Name : LITTER TIE DOWN ASS'Y (LOCKING)
 Part Number : D2360
 Drawing Number : D2360 REV. C1
 Project Number : N/A
 Drawing Revision : C1
 Material : *NIA*
 Due Date : 4/6/2006 Qty: 5 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6201 T Extrusion 4X4X3/8



Comment: Qty.: 1.1067 f(s)/Unit Total : 5.5335 f(s)
 Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion)
 Batch: *819992* *ml 06/04/02* *5*

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 12.65" Long *ml 06/04/02* *5*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio D2341 and Dwg D2341 *Ep 06/04/02* *5*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE *Ep 06/04/02* *5*

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK *J.L 06-04-03* *5*

6.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Deburr and Tumble *J.G/En 06/04/03* *5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date:
User:

Thursday, 3/30/2006 10:05:37 AM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 26443

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BC

06-04-04

5

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m

06-04-04

(5)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m

06-04-04

(5)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL

06/04/05

(5)

11.0

D2002015

Knob



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Knob

B 16 1770

FF

06.05.02

3

12.0

D2345

Lock Channel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Lock Channel

B 18545 - 26457

13.0

D2366

Lock Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Inventory

B 19248

14.0

D2367

Handle Knob



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Inventory

B 18243

B 26592 + (3)

FF

06.05.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 26443

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Quick Release

⑧ 19 289
③ 19 509

B19507 ⑥ FF 06.05.02 3

16.0

D2373

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Spring

B 19503 ✓

17.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pip Pin Assembly

D 25824 ✓

18.0

AN526C1032R18

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Screw

M 4523 ✓

19.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Washer

M 19521 ✓

20.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)
Washer

~~M 18235~~ M 100793 6x ✓

21.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Rivet, Universal Head

M 15541 ✓

22.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)
Nut

M 18917

FF 06.05.02 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: SD Date: 06/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 26443

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Screw

M13719 ✓

24.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
Screw

M15432 ✓

25.0

NAS679A3W

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Nut

M2409 (3) FF 06.05.02 3
M19437 SR 06/04/06 (2)

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D2360

FF 06.05.02 3

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.05.03 3

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST171

C206105103 (3)

29.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

06/05/04 (3)

Job Completion



4 06.05.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>BW</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>D108</i>	DRAWING NO. D2360	REV. C SHEET 1 OF 2
DATE 97.08.27		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) SCALE	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
<i>C1</i>	<i>02.09.24</i>	<i>D2002-015 WAS D2376</i>	

RELEASED
97 08 27 BW

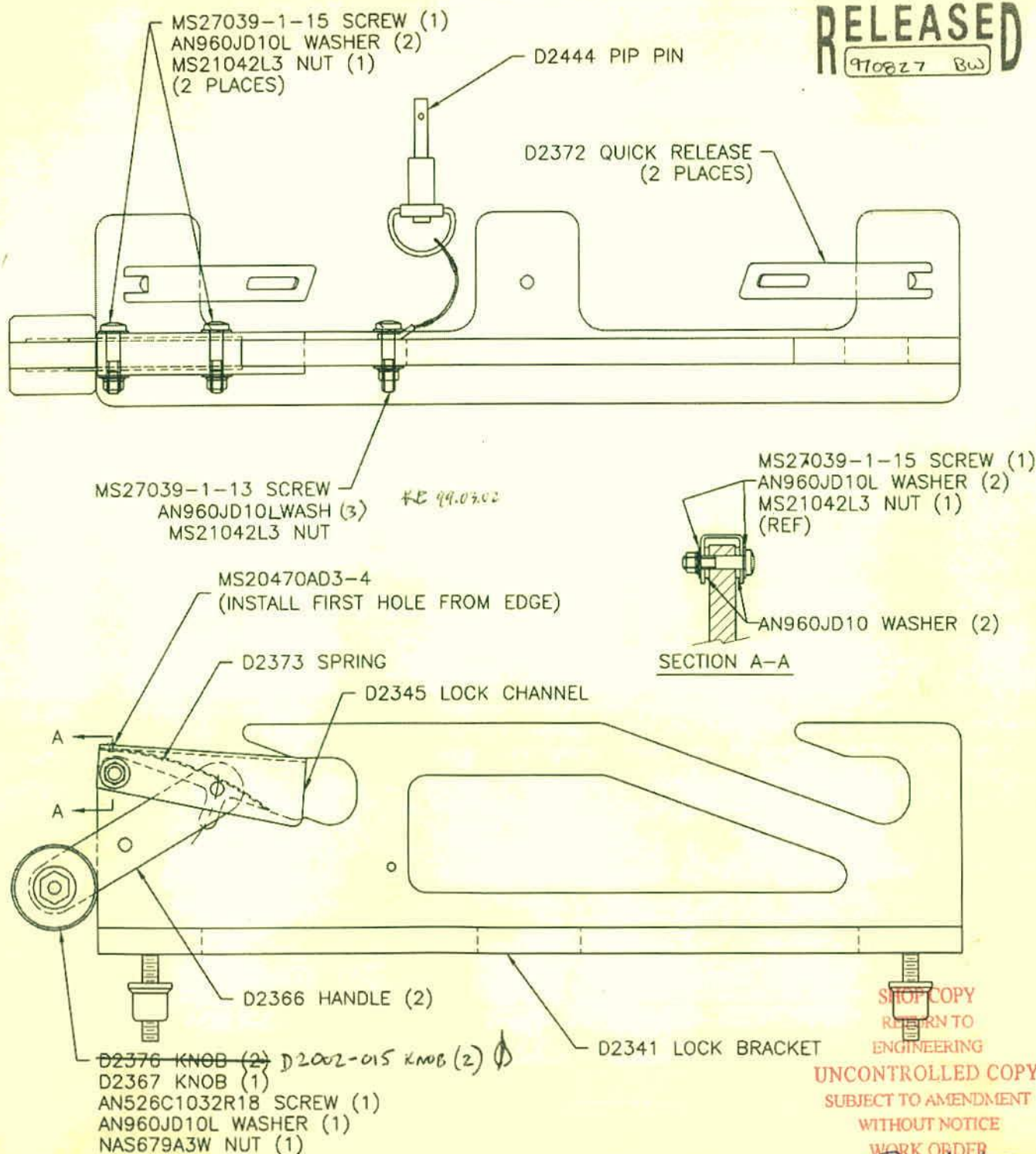
D2360	Part No.	Description
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2376	KNOB (DELRIN) <i>D2002-015</i>
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
<i>3 2</i>	AN960JD10	WASHER
<i>5 3</i>	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

KE 99.03.02

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *26443*

DART

DESIGN <i>BW</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>MB</i>	DRAWING NO. D2360	REV. C SHEET 2 OF 2
DATE 97.08.27		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING)	SCALE

RELEASED
970827 BW

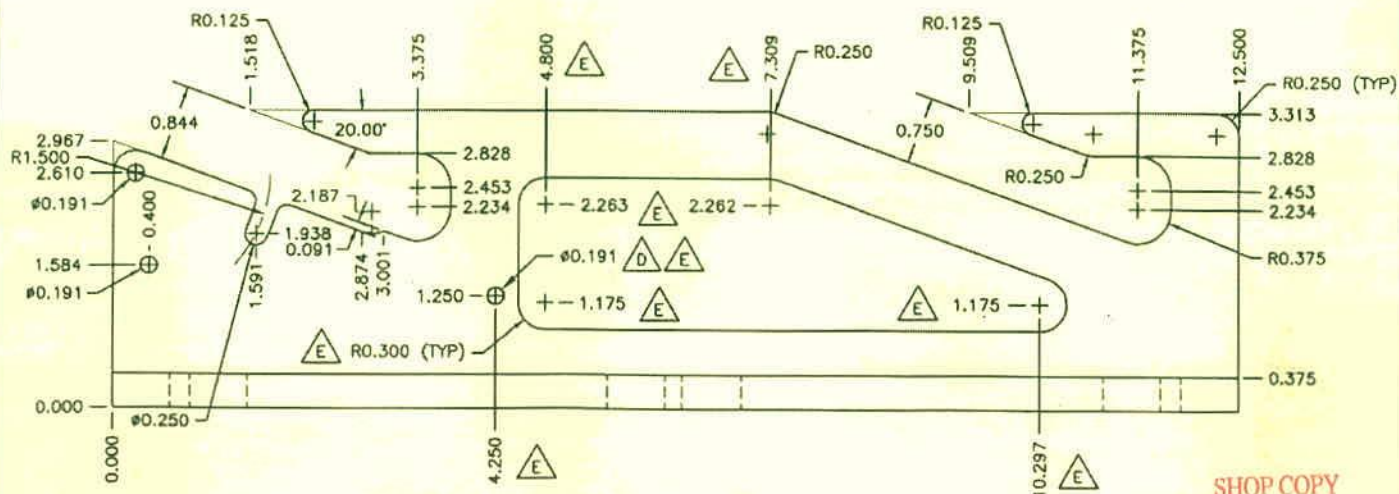
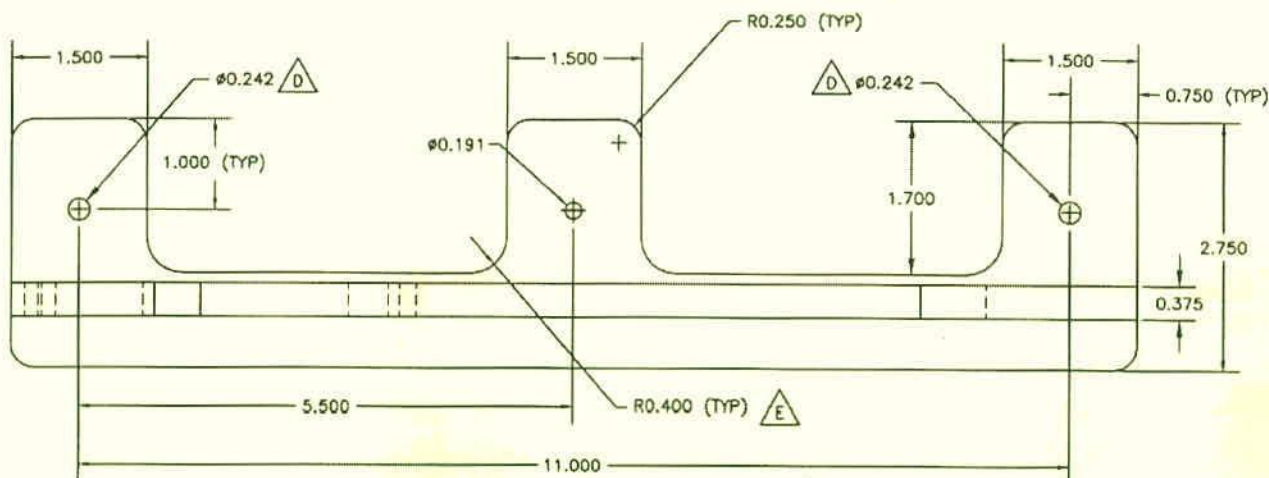
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WITHOUT NOTICE
WORK ORDER
NO. 26443

DART**RELEASED**

971003 KE

TSR A130

DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MAY	APPROVED BW	DRAWING NO. D2341	REV. E SHEET 1 OF 1
DATE 97.10.01		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	



MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION
FINISH: ANODIZE

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 26443

175

AEROSPACE LTD

Work Order:

26443

Part Name: L-1702 Tie Down Bracket

Part Number:

D2360

Drawing Dwg: D2341

Rev: E

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.500	± 0.040	1.506	-			
4.0242	± 0.0005 ± 0.001	0.242	-			
1.000	± 0.010	1.001	-			
0.191	± 0.005 ± 0.001	0.191	-			
1.500	± 0.010	1.502	-			
2.0250	± 0.010	2.250	-			
1.700	± 0.010	1.693	-			
1.500	± 0.010	1.502	-			
0.750	± 0.010	0.750	-			
2.750	± 0.010	2.752	-			
0.375	± 0.010	0.371	-			
11.000	± 0.010	11.000	-			
20.400	± 0.010	0.400	-			
5.500	± 0.010	5.499	-			
0.191	± 0.005 ± 0.001	0.191	-			
1.584	± 0.010	1.574	-			
0.400	± 0.010	0.397	-			
2.610	± 0.010	2.606	-			
0.844	± 0.010	0.844	-			
1.591	± 0.010	1.591	-			
2.828	± 0.010	2.823	-			
1.250	± 0.010	1.243	-			
4.250	± 0.010	4.249	-			

Measured by:

En

Audited by:

m

Prototype Approval:

Date:

06/04/03

Date:

06/04/03

Date:

Rev

Date

Change

Revised by

Approved

A

New Issue

KJ/RF

0.01

26443

Letter Tie Down Bracket

D 2360

DZ341

REV. E

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototyp :

Part Name	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\phi 0.191$ $+0.005$ -0.001	0.191	✓			
0.750 ± 0.016	0.758	—			
12.500 ± 0.016	12.500	—			
3.313 ± 0.010	3.321	—			
0.375 ± 0.010	0.375	—			

5

Audited by:

7/17

Prototype Approval:

06/04/03

Date:

06/04/03

Date: _____

Revised by

【KJ】

Approved

MS